

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014219**Date Inspected:** 23-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sub-Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This Quality Assurance Inspector performed document control for Phased Array Ultrasonic Testing Training, including copying training documents and development of trainee binders with literature for training class and preparation of material prior to class being given at the above-mentioned location.

This Quality Assurance Inspector performed joint Visual Inspection of welder training mock-up Deck Panel identified as MU1-001 with ZPMC and ABF Certified Welding Inspectors (CWI). Underfill, Undercut, Porosity, Overlap of the completed welds were marked for repair. Other minor cosmetic inconsistencies were marked for blending (grind) were required.

This QA Inspector was present for an impromptu coordination meeting between ZPMC Deck Panel Engineer identified as Mr. Xiong, ABF Welding Engineer identified as Peter Ferguson, ZPMC CWI Sun Bo and ABF Wang Wen Guang regarding the Visual Inspection requirements for the U-rib to Deck panel welds, as well as tentative schedule for non-destructive testing of the training mock-up deck panel and the associated requirements.

This QA Inspector gave training to certified level 2 and level 3 UT technicians in the performance of Phased Array Ultrasonic Testing, including Theory, Practical application and Specific requirements.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
